

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016003**Date Inspected:** 02-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 11

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040736 perform FCAW welding on; Lift 13 Components, Bike path and the weld joint is identified as BK 004A7-018-040.

ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133. (Photo attached)

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 251194/ 041271 perform SMAW welding on; East shaft, Lift 5, intersection diaphragm plate to outside Skin E and the weld joint is identified as ESD1-TL5-2 B/F-27, 29. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3313-TC-P5.

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046704 perform SMAW welding on; Lift 4 & 5, interior splice plate and the weld joint is identified as ESD1-SPSA5-17-3B. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1. (Photo attached)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040656 perform SMAW welding on; Lift 4 & 5, interior splice plate and the weld joint is identified as WSD1-SPSA5-17-1B. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3211-TC-U5B-1.

Bay no.10

5.This QA inspector, Baskar Govindarajan, observed ZPMC qualified welding personnel identified as 207745 perform SAW welding on; Bike path plates, and the weld joint is identified as BK 007A1-001-009. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

6.This QA inspector, Baskar Govindarajan, observed ZPMC qualified welding personnel identified as 053869 perform FCAW welding on; Façade manhole plates, and the weld joint is identified as SD1-SFSA4-7-13/14. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-13-U2-F-2.

7.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052493 perform SMAW welding on; South shaft, Lift 5, intersection diaphragm plate to inside Skin C and the weld joint is identified as SSD1-TL5-1 B/F-80. ZPMC CWI Identified as Mr. Xu Le Feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3313-TC-P5.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
